

Date: Wednesday, 11/03/2009 12:59:06 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 46445
 Estimate Number : 12784
 P.O. Number :
 This Issue : 11/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 45825

Drawing Name : WEARPAD

D3564-3

Part Number : D3564
 Drawing Number : D3564 REV D
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 23/03/2009

Qty: 12 Um: Each

Written By :
 Checked & Approved By : JUL 09 03 11
 Comment : Est Rev:A New Issue 07-03-08 ec
 Est Rev:B As per Rev C 07-07-09 JLM
 Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 Sheet-063



Comment: Qty.: 1.1550 sf(s)/Unit Total 13.8600 sf(s)
 M304S16GA Stainless steel sheet 0.063" thick
 Batch: 105551

ml 09 03 17 (12)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3564 ***** (D3564-1F) *****
 Dwg Rev: D
 Prog Rev: D

2-Deburr if necessary

ml 09 03 17 (12)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 03 17 (12)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 09/03/17 (12)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1/5 Deburr if necessary
 Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155

SB 09/03/25 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 12:59:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 46445

Part Number: D3564

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggle as per Dwg D3564 on brake using Jig DT 8157

u/a not on - 3's

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

809/03/25 (+12)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 2059B Hardcoat

1111036

Weld hardcoat as per Dwg D3564

EL 9-3-31 x12

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

809/03/31 (+12)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

809/03/31 (+12)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

1109648

START TIME:

11:15

OVEN TEMPERATURE:

320°

FINISH TIME:

11:45

BR 09-04-2

(12)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-02

(12)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-19

BR 09-04-2

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 12:59:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 46445

Part Number: D35641-3

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CY 09/04/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>H6445</u>
Description: Wearshoe		Part Number: <u>D3564-0-3</u>
Inspection Dwg: D3564	Rev: D	Page 1 of 1

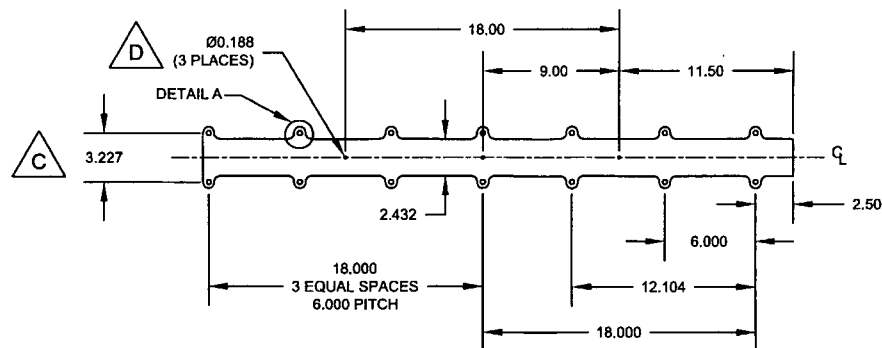
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

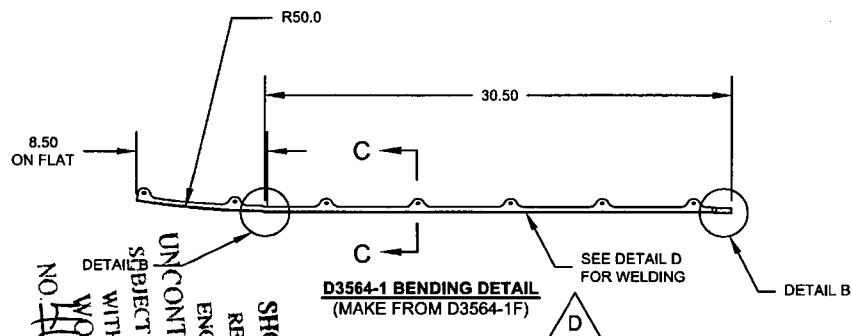
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.223	✓		VERN	
2.432	+/-0.010	2.433	✓		VERN	
2.50	+/-0.030	2.50	✓		VERN	
6.000	+/-0.010	6.005	✓		VERN	
12.104	+/-0.010	12.104	✓		M-T	
18.000	+/-0.010	18.000	✓		M-T	
18.000	+/-0.010	18.000	✓		M-T	
18.00	+/-0.030	18.00	✓		M-T	
9.00	+/-0.030	9.00	✓		M-T	
11.50	+/-0.030	11.50	✓		M-T	
0.300 x 0.300	+/-0.010	0.303x0.301	✓		VERN	
Ø0.188	+0.005/-0.001	0.188	✓		VERN	
R0.375	+/-0.010	R0.375	✓		R-G	
0.063	+/-0.010	0.059	✓		VERN	

Measured by: <u>M.M</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>09.03.17</u>	Date: <u>09/03/17</u>	Date:	N/A

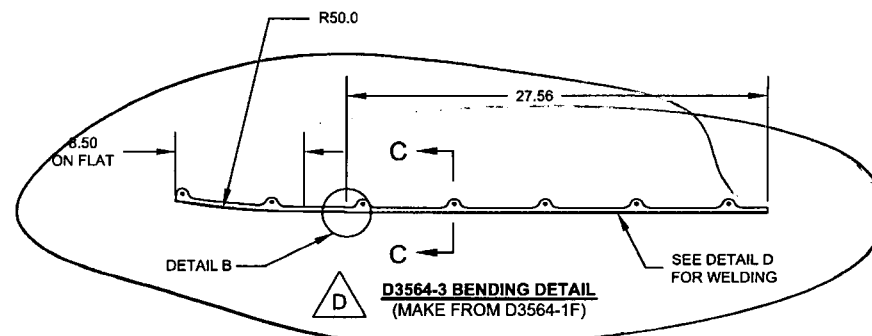
Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD <u>A</u>	<u>D</u>



D3564-1F FLAT PATTERN



**D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)**



**D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)**

RELEASED

07.09.04

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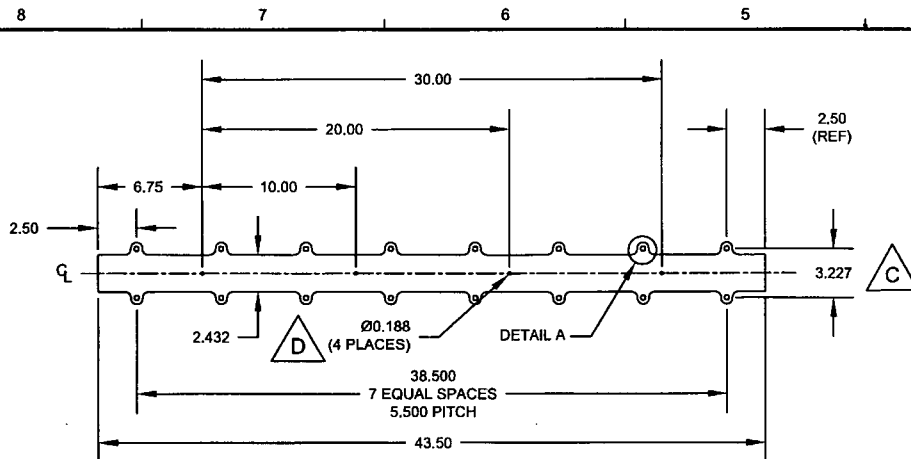
D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT CL

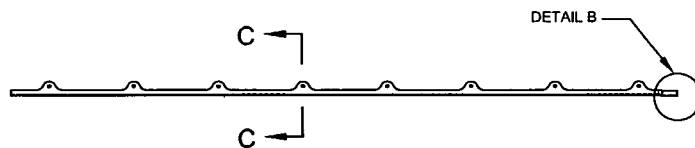
WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8, PG3 B5,C5; ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

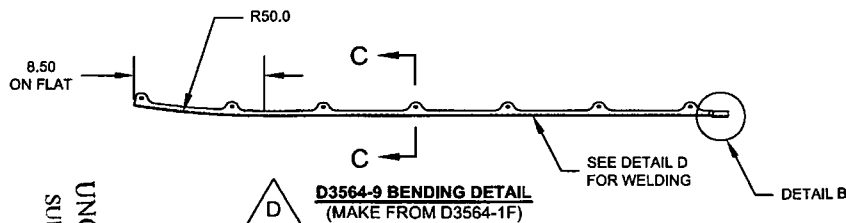
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3564	REV. D SHEET 1 OF 3
TITLE WEARSHOE	SCALE 1:8
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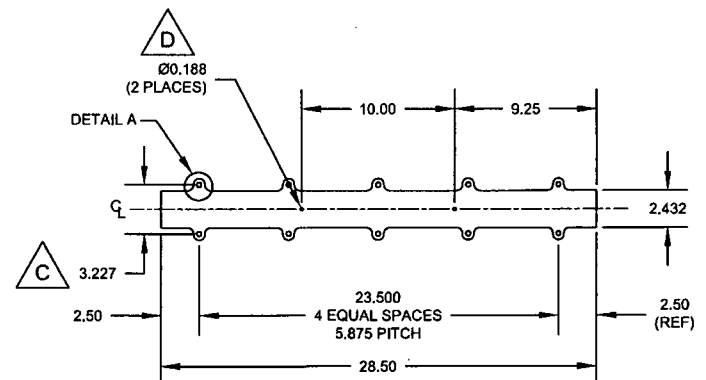
D3564-5F FLAT PATTERN



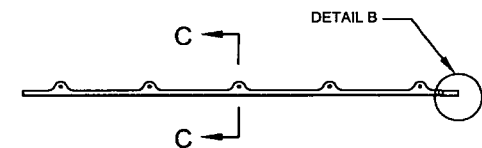
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



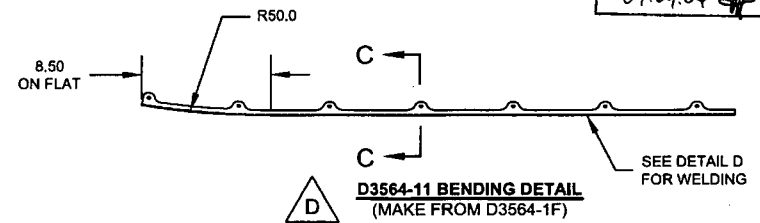
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



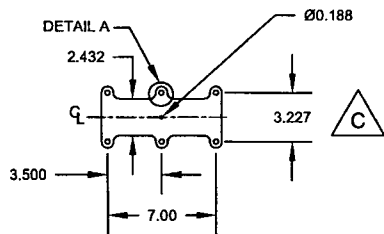
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

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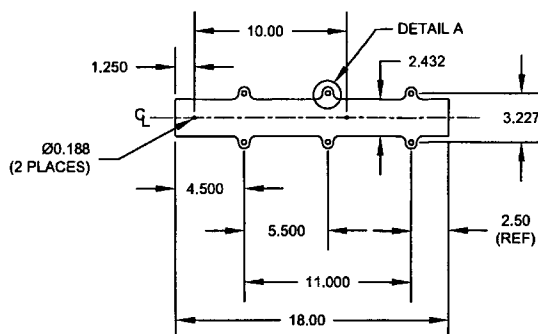
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DRAWN	CB		
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DE APPR.	PH		
DATE	07.08.21		

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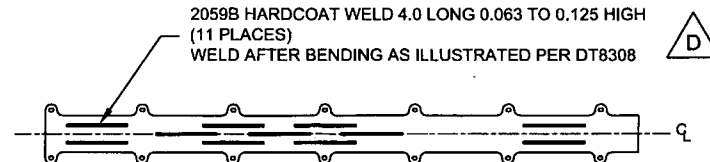
8 7 6 5 4 3 2 1



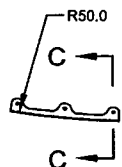
D3564-13F FLAT PATTERN



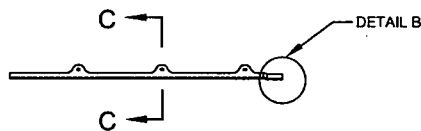
D3564-15F FLAT PATTERN



DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



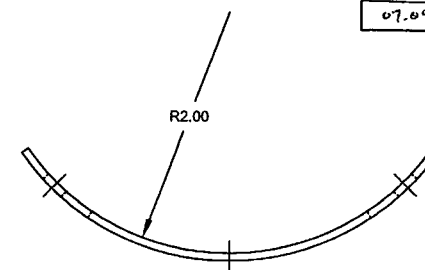
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



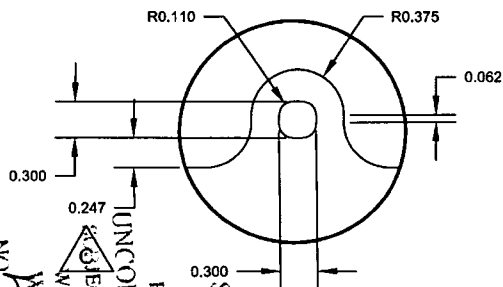
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

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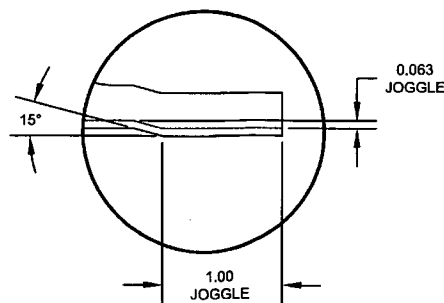
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

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CHECKED	PH	DRAWING NO.	REV. D
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